

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029541**Date Inspected:** 18-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various Complete Joint Penetration (CJP) groove welds of the East and West Orthotropic Box Girders (OBG's).

The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

This QAI observed grinding and touch-up welding of seal cover plates at 12E-PP119(-1500)-E3 towards final visual inspection and Magnetic Particle/MT inspections. Welder Earl Clayborn #5070 was performing the welding utilizing E7018 electrodes per WPS ABF-WPS-D15-F1200A and AB/F RFI #0033256R00. AB/F QC William Sherwood was present.

This QAI witnessed welding of full penetration butt splice of 4 inch diameter pipe of the compressed air line located at the Bikepath 18-4-17-BE. F.W. Spencer welder, Rick Kickvee #5319, performed this weld utilizing E6010 electrodes for root pass, and E7018 electrodes for fill and cap passes as per WPS #1-12-1. AB/F QC Fred Michels was present.

This QAI observed the preheat and the in-progress welding of the seal cover plate at 12E-PP119(+1500)-E3 as per AB/F RFI #003256R00. Welding was performed by Lin E. Yun #9344 utilizing E7018 electrodes per WPS ABF-WPS-D15-F1200A. No AB/F QC was present at this time.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

No significant conversations took place.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Morris, Monty
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Reyes, Danny
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QA Reviewer
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